

Work Order ID **95065*****95065***

Page 1

January-02-13 12:59:53 PM

Item ID: D3186-1M Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: SPACEPOD DOOR LH
Start Date: 1/02/13 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/25/13 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: ML5 Date: 13-01-03 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3186	Rev E

100 PURCHASING 0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 18720

Description: D3186-1M Door

Ship to Delastek (1) D0600-XXX label

Batch: N/A C&I 5102127

Supplier: Delastek

Conformity Certificate and Process sheet required

C&I 13/01/15 ①

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

13/3/13 ⑥

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Misread
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Offset
☐ Ripples in Bend	☐ Drill Holes	☐ Out of Calibration
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Sequence
☐ Turning Sequence	☐ Finish	☐ Outside Dimensions
☐ Wave/Twist in Tube	☐ Folio	
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

Work Order ID 95065***95065***

Page 2

January-02-13 12:59:53 PM

Item ID: D3186-1M Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: SPACEPOD DOOR LH
Start Date: 1/02/13 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/25/13 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control	Check for void spot and pins. Ensure surface of doo is smooth, no dimples for drilling.								
130	Identify as per dwg & Stock Location: <u>CA2</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

FEB 26 2015

45 15-02-26

MUT 15-02-27

W (S-02-25)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data ☐												
Equip/Tooling ☐												
Operator ☐												
Material ☐												
Setup ☐												
Other ☐												
Process ☐												
Supplier ☐												
Training ☐												
Unapproved ☐												
FAULT CATEGORY												
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped. ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	

Picklist Print

January-02-13 12:59:53 PM

Page 1

Work Order ID: 95065

Parent Item: D3186-1M

Parent Item Name: SPACEPOD DOOR LH

Start Date: 1/02/13

Required Date: 1/25/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-12-04 ec
IPP rev D rv D dwg 07.03.07 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-1P Spacepod Door		Purchased	No			110	Each	0.0000	1	1			

43/3/13 @

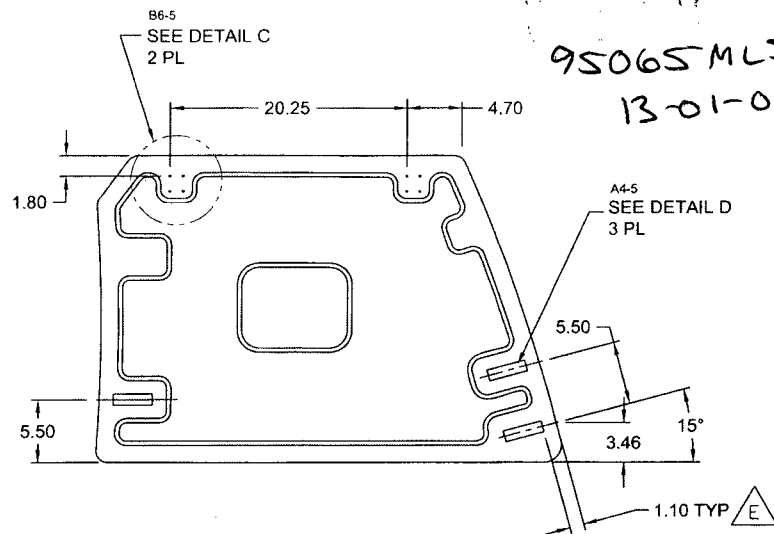
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

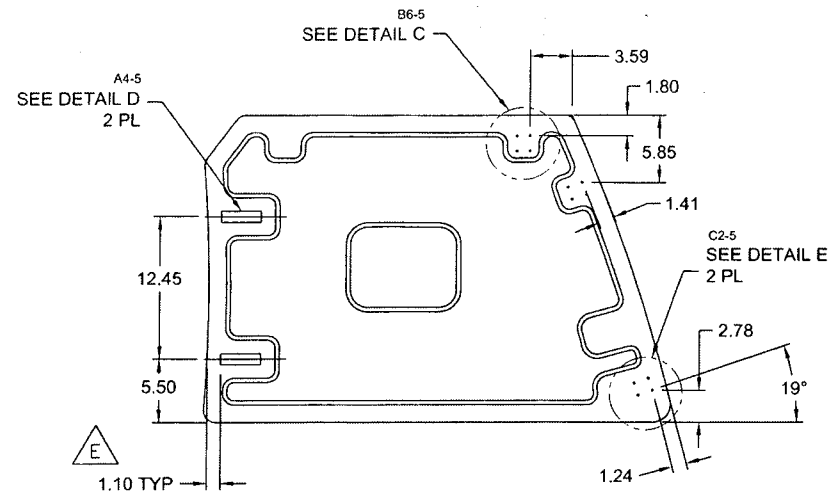
Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data ☐												
Equip/Tooling ☐												
Operator ☐												
Material ☐												
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Other ☐												
Process ☐												
Supplier ☐												
Training ☐												
Unapproved ☐												
FAULT CATEGORY												
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped. ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

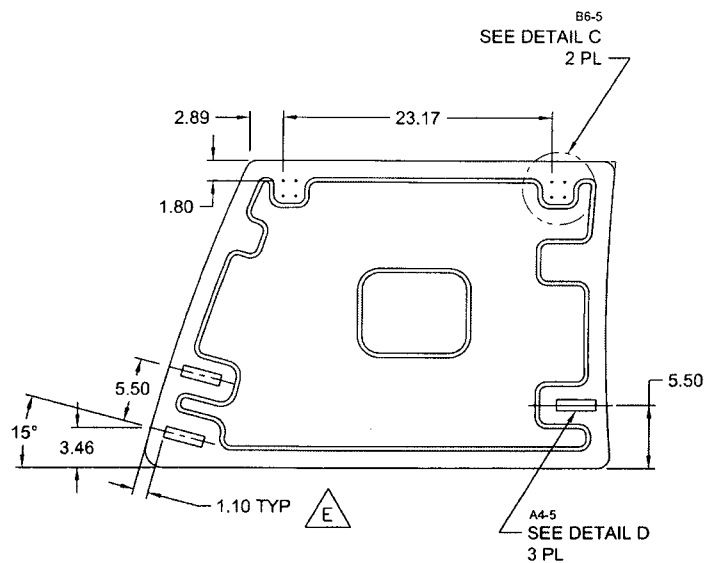


D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

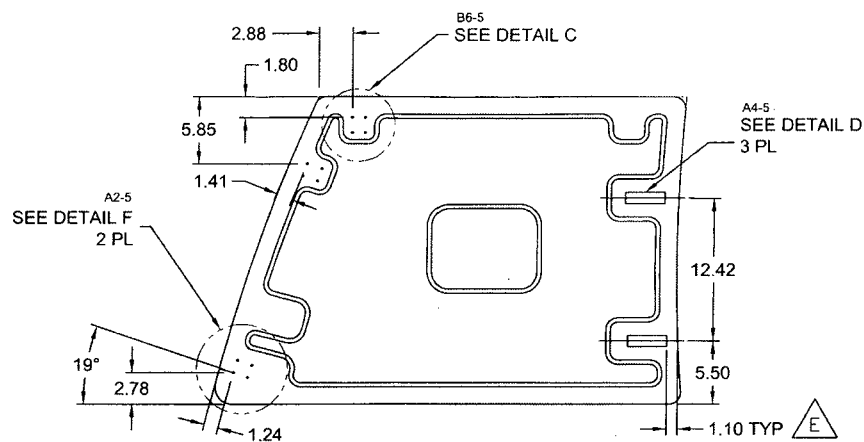
RELEASED
2009-09-09

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	IP	DRAWING NO.	REV. E
MFG. APPR.	AS	D3186	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	SPACEPOD DOOR	NTS
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95065



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



D3186-4 SPACEPOD DCOR, RH
MAKE FROM D3186-2M

RELEASED
2009-09-09

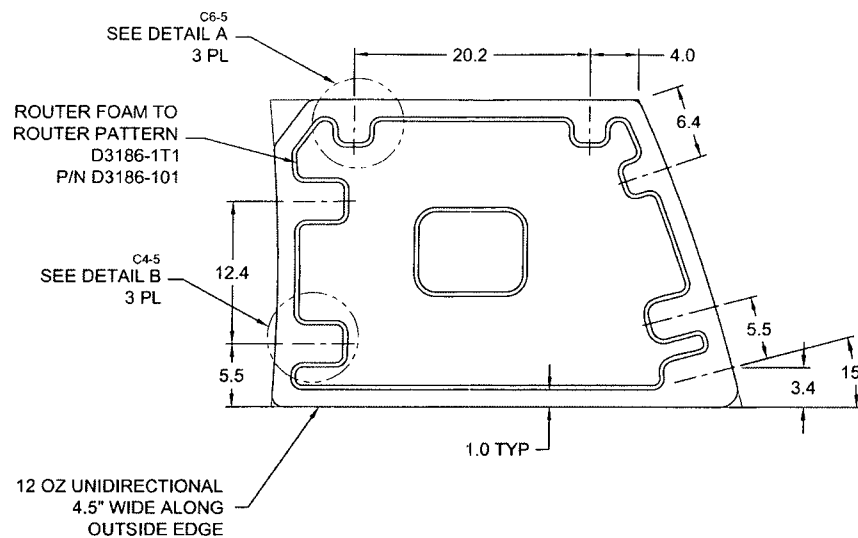
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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95065

MAIN LAYUP
 9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



D3186-1M SPACEPOD DOOR AS MOLDED

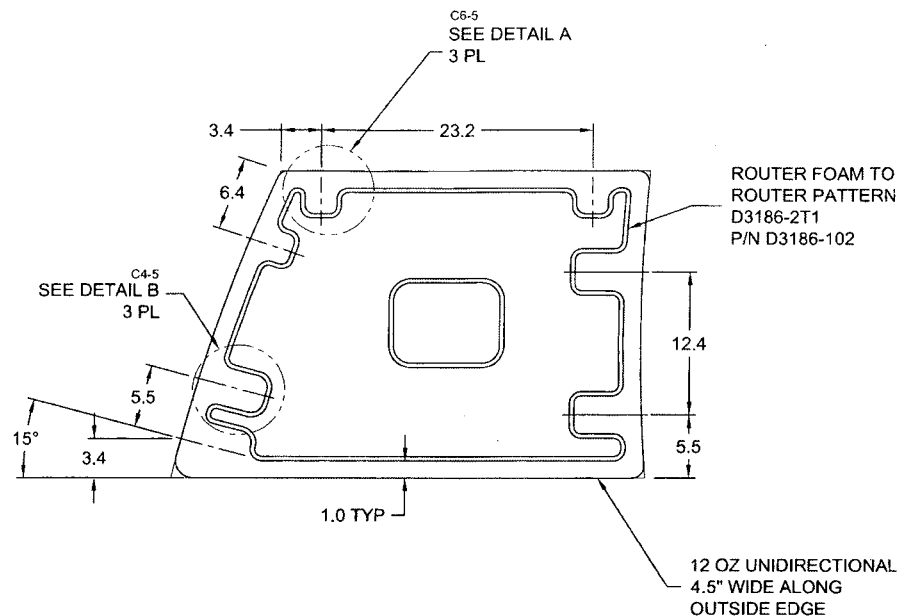
NOTES:

- 1) MATERIAL:
 RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8005 FOR DOOR LAYUP

RELEASED
 2009-08-08

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECCELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING

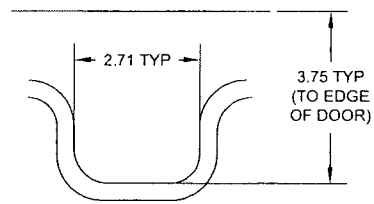
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8006 FOR DOOR LAYOUT

D3186-2M SPACEPOD DOOR AS MOLDED

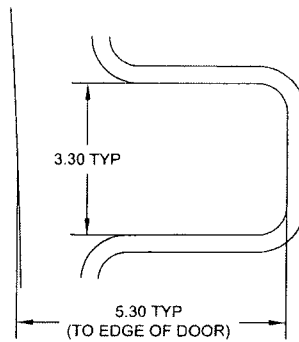
RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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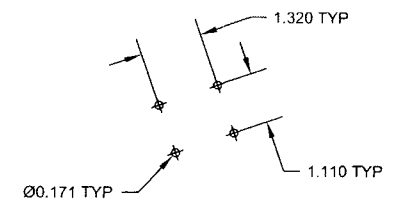
95065



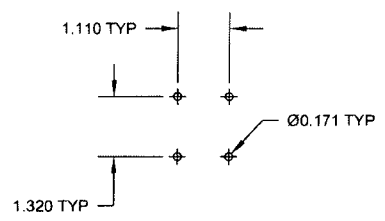
DETAIL A D6-3
SCALE 4X D4-4



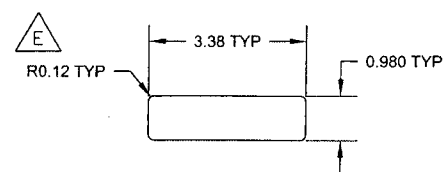
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

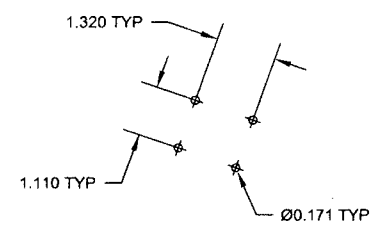


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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DELASTEK Inc.
2699 5e Avenue
Local 14, C.P. 10100
Grand-Mère, Québec G9T 5K7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	47392
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
12-03-2013	22-01-2013	22731	Brigitte Golden	18720	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX P1 Collect		Point de départ		Mathieu Doucet, ext.690	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0058	Line 1 D31861P Spacepod Door LH B95065 U of M: Chaque Dwg. Rév.: E Serial # Lot # B95065 48897	
1	0	1	DKC134-0060	Line 3 N° D3186-2M Spacepod Door RH B95160 U of M: Chaque Dwg. D3186 Rév.: E Serial # Lot # B95160 48898	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Quality department

AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mercredi, 2013-01-30 10:29:05
Utilisateur: Mario Chantal

Feuille de Procédé

4 / 20 Janv.

Client	: DART US DART AEROSPACE	Nom Dessin	: SPACEPOD DOOR LH
Numéro Job	: 48897	Numéro Article	: DKC134-0058
Numéro	: 3411	Numéro Dessin	: -
Numéro B.A.	:	Projet Numéro	: DK-359
Cette fois	: 2013-01-30 No. :	Révision dessin	:
Prsht Rev.	: NC	Matériel	: 7781 & 411-350
Prem. fois	: - - Type :	Date Due	: 2013-02-25 Qté: 1 Ud UNITE
Job précédente	: 43679		

Écrit par : NC 4270

Vérifié & Approuvé par :

Commentaires : N° de dessin: D31861M rev. E

E.O.: N/A

Feuille de Procédé Rév.: 04 AMB0349 remplacé par
AMB0511 (réf. RFC #226)

Formulaire d'inspection: N/A

B95065

Produit additionnel

Numéro Job:



Séq.: Machine ou Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Comment Qty.: 0.020 UNITE(s)/Unit Total : 0.020 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 1-37420

2.0 PRÉPARATION Préparation du moule



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DT 8005 selon IG 0009.

Date: 15/02/13 Sceau:

3.0 AAC1885 Tissu à délaminer Release ply B

Comment Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)
Tissu à délaminer Release ply B # de Lot: N/A

4.0 AAC1887 Wrighton 5200 Bleu P3

Comment Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)
Wrighton 5200 Bleu P3 # de Lot: N/A

5.0 AC0885 Feutre de drainage N° Airweave N 10

Comment Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)

Date: Mercredi, 2013-01-30 10:29:05
Utilisateur: Mario Chantal

Feuille de Procédé

Client:	DART US DART AEROSPACE		Nom Dessin:	SPACEPOD DOOR LH
Numéro Job:	48897		Numéro	DKC134-0058
Numéro Job:				
# Séq.:	Machine ou Opération:	Description :		
6.0	AC0943	Stretchlon 200 poche à vide Vert		
Comment	Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)			
7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish		
Comment	Qty.: 4.5 VERGE(s)/Unit Total : 4.5 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-39576-1			
8.0	AC0886	Ruban à gommer jaune #: T/AT-200Y		
Comment	Qty.: 2.2500 ROULEAU(s)/Unit Total : 2.2500 ROULEAU(s)			
9.0	AMB0511	N° TG-13-U, Fiberglass 13 oz		
Comment	Qty.: 1.00 VERGE(s)/Unit Total : 1.00 VERGE(s) N° TG-13-U, Fiberglass 13 oz N° de Lot: 1-36302-1			
10.0	PREP-GENERAL	Préparation du matériel		
				
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs Tailler le matériel selon les différents patrons de découpe Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide. Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres Date: 14/02/13 Sceau: 			
11.0	AMB0286	Catalyst N° DDM-9		
Comment	Qty.: 0.0080 GALLON(s)/Unit Total : 0.0080 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27829-1			
12.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.		
Comment	Qty.: 0.500 LITRE(s)/Unit Total : 0.500 LITRE(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-39253-1			
13.0	PREP-GENERAL	Préparation du matériel		
				
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine. Date: 15/02/13 Sceau: 			

Date: Mercredi, 2013-01-30 10:29:05
Utilisateur: Mario Chantal

Feuille de Procédé

Client:	DART US DART AEROSPACE		Nom Dessin:	SPACEPOD DOOR LH
Numéro Job:	48897		Numéro	DKC134-0058
Numéro Job:				
# Séq.:	Machine ou Opération:	Description :		
14.0	LAMINAGE	Faire le laminage		
				
Comment	Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs			
	À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz.			
	Recommencer l'opération pour le 2e pli			
	Date: 15/02/13	Sceau: 		
15.0	BAGGING	Faire le bagging sur la pièce		
				
Comment	Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
	Faire la poche à vide selon IG 0012.			
	Laissez Sécher 4 heures minimum			
	Heure début Curing: 11:15			
	Heure Fin Curing: 8:00			
	Date: 15/02/13	Sceau: 		
16.0	AMB0286	Catalyst N° DDM-9		
Comment	Qty.: 0.0120 GALLON(s)/Unit Total : 0.0120 GALLON(s)			
	Catalyst N° DDM-9 N° de Lot: 1-27827-1			
17.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.		
Comment	Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)			
	Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-27754-1 1-39738-1			
18.0	PREP-GENERAL	Préparation du matériel		
				
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs			
	Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbiber toutes les surfaces du Foam Core selon IG0105.			
	Date: 19/02/13	Sceau: 		
19.0	DKC134-0056	Foam Core N° D3186-101 (Porte D3186-1)		
Comment	Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)			
	Foam Core N° D3186-101 (Porte D3186-1) N° de Job: 49321			

Date: Mercredi, 2013-01-30 10:29:05
Utilisateur: Mario Chantal

Feuille de Procédé

Client:	DART US DART AEROSPACE		Nom Dessin:	SPACEPOD DOOR LH
Numéro Job:	48897		Numéro	DKC134-0058
Numéro Job:				
# Séq.:	Machine ou Opération:	Description :		
20.0	AAC1611	Polybond B46F		
Comment	Qty.: 0.090 KIT(s)/Unit Total : 0.090 KIT(s) Polybond B46F N° de Lot: <u>1-29934-1</u>			
21.0	ASSEMBLAGE	Assemblage mécanique		
				
Comment	Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs Retirez le bagging. Pour aider au positionnement de 13 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage. Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.) Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0056 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet. Date: <u>21/02/13</u> Sceau:  			
22.0	BAGGING	Faire le bagging sur la pièce		
				
Comment	Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs Faire la poche à vide selon IG 0012. Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond. Heure début Curing: <u>11:30</u> Heure Fin Curing: <u>1:00</u> Date: <u>21/02/13</u> Sceau:  			
23.0	AMB0286	Catalyst N° DDM-9		
Comment	Qty.: 0.0400 GALLON(s)/Unit Total : 0.0400 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>			
24.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.		
Comment	Qty.: 1.000 LITRE(s)/Unit Total : 1.000 LITRE(s) Résine (411B7530) 411-350 promo. 75min N° de Lot: <u>1-39758-1</u>			

Date: Mercredi, 2013-01-30 10:29:05
Utilisateur: Mario Chantal

Feuille de Procédé

Client	DART US DART AEROSPACE		Nom Dessin:	SPACEPOD DOOR LH
Numéro Job:	48897		Numéro	DKC134-0058
Numéro Job:				
# Séq.:	Machine ou Opération:	Description :		
25.0	PREP-GENERAL	Préparation du matériel		
				
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs			
	Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.			
	Date: <u>25/02/13</u> Sceau:  			
26.0	LAMINAGE	Faire le laminage		
				
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs			
	Faire le laminage d'un pli de 9.7 oz.			
	Faire le laminage d'un pli de 13 oz. tout le tour de la porte.			
	Faire le laminage d'un pli de 9.7 oz.			
	Date: <u>25/02/13</u> Sceau:  			
27.0	BAGGING	Faire le bagging sur la pièce		
				
Comment	Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
	Faire la poche à vide selon IG 0012.			
	Laissez Sécher 4 heures minimum			
	Heure début Curing: <u>1:30</u> Heure Fin Curing: <u>1:00</u>			
	Date: <u>25/02/13</u> Sceau:  			
28.0	DÉMOULAGE	Démoulage de la pièce		
				
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs			
	Démouler la pièce en faisant bien attention aux coins & rebords selon IG 0018.			
	Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.			
	Date: <u>7/03/13</u> Sceau: 			

Date: Mercredi, 2013-01-30 10:29:05

Utilisateur: Mario Chantal

Feuille de Procédé

Client:	DART US DART AEROSPACE		Nom Dessin:	SPACEPOD DOOR LH
Numéro Job:	48897		Numéro	DKC134-0058
Numéro Job:				
# Séq.:	Machine ou Opération:	Description :		
29.0	TRIMAGE	Trimage		
				
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs			
	Trimer le contour de la pièce à l'aide du gabarit de trimage identifié au # de pièce.			
	Date: <u>8/03/13</u> Sceau: 			
30.0	AAC1021	Dupont Primer N° 7704S		
Comment	Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)			
	Dupont Primer N° 7704S N° de Lot: <u>1-36423-1</u>			
31.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase		
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)			
	N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-38821-1</u>			
32.0	PRIMER	Application primer		
				
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs			
	Préparer la pièce et Appliquer le primer selon IG 0008.			
	Date: <u>8 mars 2013</u> Sceau:  Fiche de mélange: <u>N/A</u> <u>1^{re} et 2^e rate</u>			
33.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler		
Comment	Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)			
	N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-39276-2</u>			
34.0	FINITION	Finition Générale		
				
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
	Faire les réparations de finition si nécessaire à l'aide du "Filler" P15-3.			
	Faire un léger sablage (Grit 220) de toutes les surfaces.			
	Heure début Curing: <u>N/A</u> Heure Fin Curing: <u>N/A</u>			
	Date: <u>9/03/13</u> Sceau: 			
35.0	AAC1021	Dupont Primer N° 7704S		
Comment	Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)			
	Dupont Primer N° 7704S # de Lot: <u>1-38821-1-36423-1</u>			

Date: Mercredi, 2013-01-30 10:29:05
Utilisateur: Mario Chantal

Feuille de Procédé

Client:	DART US DART AEROSPACE		Nom Dessin:	SPACEPOD DOOR LH
Numéro Job:	48897		Numéro	DKC134-0058
Numéro Job:				
# Séq.:	Machine ou Opération:	Description :		
36.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase		
Comment	Qty.: 0.0300 UNITE(s)/Unit Total : 0.0300 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase # de Lot: <u>1-38821-1</u>			
37.0	PRIMER	Application primer		
				
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer le primer selon IG 0008. Date: <u>09/03/13</u> Sceau: <u>453214</u> Fiche de mélange: <u>N/A</u>			
38.0	INSPEC FINAL	Inspection finale		
				
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Faire l'inspection finale par la qualité selon le dessin. Date: <u>11 mars 13</u> Sceau: 			
39.0	EMBAL / ENTREPO	Emballage & Entreposage		
				
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Emballer et entreposer selon IG 0057. Date: <u>11-3-13</u> Sceau: 			